

87085

July-10-12 3:05:28 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/10/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 12-07-11 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D407-802-1	A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D407-802-017 CHG00

105

Pick Kit

0.00

105

Pick Kit

Packaging

Memo

0.00

Packaging

110

QC4- 100% Inspect kits for completeness

0.00

110

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July-10-12 3:05:28 PM

Item ID: D407-802-017

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Passenger Door Opener Installation, LH

Stop *NS2*

Start Date: 7/10/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 7/10/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00

120

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPPD407-802-017

Location: 21B
PPP rev: _____

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MF
12-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 3:05:27 PM

Page 1

Work Order ID: 87085

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 7/10/12









Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.27 new issue DD verf:EC
rev.A DD verf:EC

IPP Rev:B 10.12.03 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D3552-17 Door Prop		Manufactured	No			105	Each	16.0000	1	88101	✓	20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST272		15							
				64338		4							
				65120		1							
				83585		10							
				ST276		1							
				69670		1							
 D3522-5 Ball Stud		Manufactured	No			105	Each	36.0000	0	1	✓	20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST058		36							
				80406		6							
				82314		30			82314				
 D4108-1 Door Doubler, Left		Manufactured	No			105	Each	5.0000	0	1	✓	20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST096		5							
				79343		5			79343				
 D4108-049 Litter Door Fitting Assembly		Manufactured	No			105	Each	4.0000	0	1	✓	20	 12/10/12
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST097		4							
				84010		4			84010				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 3:05:27 PM

Page 2

Work Order ID: 87085

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

GR3523-4-03

RIVET

Purchased No

105 Each 47.0000

21

21

122378

20

50

Location

Loc Qty

Loc Code

ST331

19

120521

19

ST332

28

112991

10

116373

18

MS20426AD4-5

Rivet

Purchased No

105 Each 4,611.0000

2

2

20

50

Location

Loc Qty

Loc Code

ST317

4611

6874

4611

6874

MS21073L5

nut plate

Purchased No

105 Each 28.0000

1

1

20

50

Location

Loc Qty

Loc Code

ST303

28

120986

8

121444

20

121444

MS21209FI-15

HELI COIL

Purchased No

105 Each 49.0000

3

3

20

50

Location

Loc Qty

Loc Code

ST305

49

120308

5

121166

44

120308

MS27039C1-06

Screw

Purchased No

105 Each 23.0000

3

3

20

12/10/12

Location

Loc Qty

Loc Code

ST293

23

115768

23

115768

July-10-12 3:05:27 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 3:05:27 PM

Page 3

Work Order ID: 87085

Parent Item: D407-802-017

Parent Item Name: Passenger Door Opener Installation, LH

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 1.00

Required Qty: 1.00

MS27039G1-09
SCREW

Purchased No

105 Each 113.0000

0 1 ✓ JB

Location

Loc Qty

Loc Code

FP002

20

17831

20

ST293

93

116290

93

MS27039G1-27
Screw

Purchased No

105 Each 7.0000

116290
2 2 ✓ JB

Location

Loc Qty

Loc Code

ST293

7

115768

7

NAS1149G0332R
Washer

Purchased No

105 Each 8,994.0000

115768
2 123 2 1/8 ✓ JB

Location

Loc Qty

Loc Code

297

8972

122063

8972

ST297

22

121509

22

NAS1149G1165R
Washer

Purchased No

105 Each 57.0000

2 2 ✓ JB

Location

Loc Qty

Loc Code

ST296

57

115768

57

NAS1149C0532R
WASHER

Purchased No

105 Each 205.0000

115768
6 122-441 12/10/12

Location

Loc Qty

Loc Code

ST297

205

116373

1

116513

51

119736

153

July-10-12 3:05:28 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-10-12 3:05:28 PM

Work Order ID: 87085

Parent Item: D407-802-017

Start Date: 7/10/12

Required Date: 7/10/12

Parent Item Name: Passenger Door Opener Installation, LH

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0563R

Purchased

No

105

Each

361.0000

6

6

Washer

✓ JB 12/10/12

Location

Loc Qty

Loc Code

ST296

200

120422

200

ST297

161

116391

8

117460

153

117460

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Worship

Description: PASSENGER DOOR OPENER, LH

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

5.3 D407-802-017/-018 Passenger Door Opener Kits

Qty -017/-018	Qty	Part Number	Description
		D407-802-017	PASSENGER DOOR OPENER KIT, LH
		D407-802-018	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	1	D3622-5	BALL STUD
1		D4108-1	DOOR DOUBLER, LEFT
	1	D4108-3	DOOR DOUBLER, RIGHT
	1	D4108-5	SMALL RIGHT DOOR DOUBLER
	1	D4108-11	TEMPLATE
	1	D4108-047	SILL DOUBLER ASSEMBLY
1		D4108-049	LITTER DOOR FITTING ASSEMBLY
	19	CR3523-4-2	RIVET
21		CR3523-4-3	RIVET
	4	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
	2	MS20426AD4-6	RIVET
1	1	MS21073L5	ANCHOR NUT
3		MS21209-F1-15	HELICOIL
3		MS27039C1-06	SCREW
1		MS27039C1-09	SCREW
2	2	MS27039C1-27	SCREW
2	2	NAS1149C0332R	WASHER
2	2	NAS1149C1165R	WASHER
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.4 D407-802-019 Baggage Door Opener Kit, Composite

Qty -019	Part Number	Description
	D407-802-019	BAGGAGE DOOR OPENER KIT, COMPOSITE
1	D3552-19	DOOR PROP
1	D4109-041	DOUBLER ASSEMBLY, BULKHEAD
1	D4109-043	DOUBLER ASSEMBLY
3	80-004-2-6	INSERT
4	MS27039C1-05	SCREW
3	MS27039C1-06	SCREW
7	NAS1149C0363R	WASHER
4	NAS1836-3-08M	INSERT